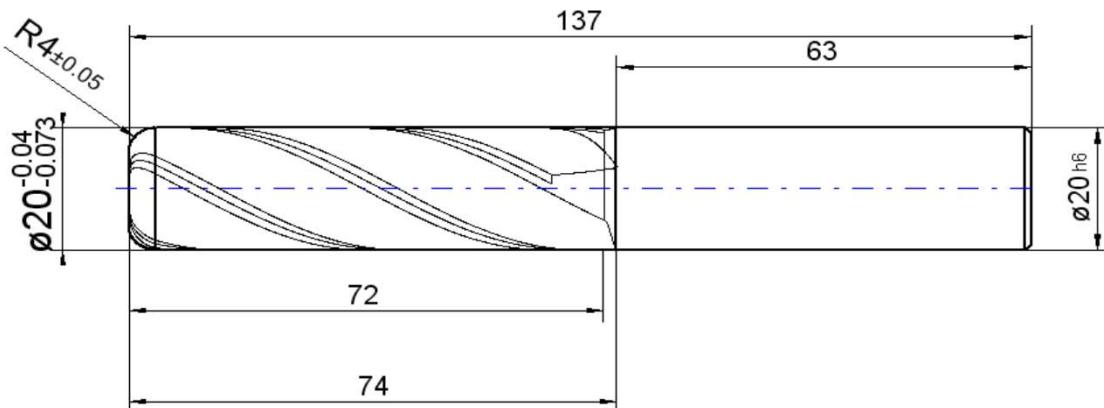


Multipitch Radius-Endmill Ø20 Z2+2 R4

A01-112



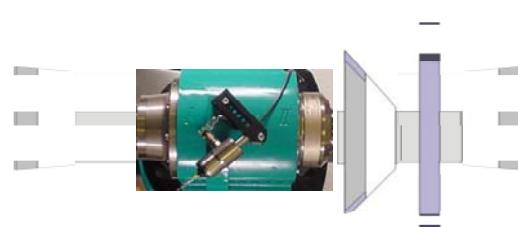
1. Cycletime for Production

Workpiece: Ø20 Ltot 137, LC 72 mm Material CARBIDE							
Operations	Probe	Flute 1	Gashing	O.D.2	O.D.1	End 2	End 1
Feed [mm/Min]	2000	40	80	150	300	70	100
Power [kW]		3	2	1	2	1	1
Cutting speed [m/s]		18	20	22	22	22	22
Used wheels		1	2	3	4	1	4
Grinding time [s]	12	583	65	436	231	57	42
Total cycle time	23 Min 45						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	12V9 Ø125 D64
3	11V9 Ø100 D64
4	11V9 Ø100 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 310i

Accessories:

Responsible engineer: OP, 27.2.14

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China

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